

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024031**Date Inspected:** 21-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#11

This QA Inspector observed the following work not in compliance:

Description of Incident:

During the Caltrans Quality Assurance (QA) in-process observation on lift-6 tower boom supports, this QA Inspector discovered the following issue:

- ZPMC personnel sealed the Tower Boom Supports without allowing for QA visual confirmation that these corrections had been completed.
- On date: 4/5/2011 it was observed that the cope hole sizes at all 4 corners on every stiffener plate of Tower Boom Supports (listed below) did not conform to shop drawing#PL7-16. (cope holes 25mm x 25mm)
- Cope hole dimensions were then changed to 15mm x 45mm per TC-RFI-369R0 to address this discrepancy.
- The tower boom supports are identified as:-

1. ESD1-TBSA7-3

2. NSD1-TBSA7-3

- These members are Non-Seismic Performance Critical Member's (SPCM).
- These components are located at fabrication Bay # 11.

For further information, please see the attached pictures below.

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Applicable reference:

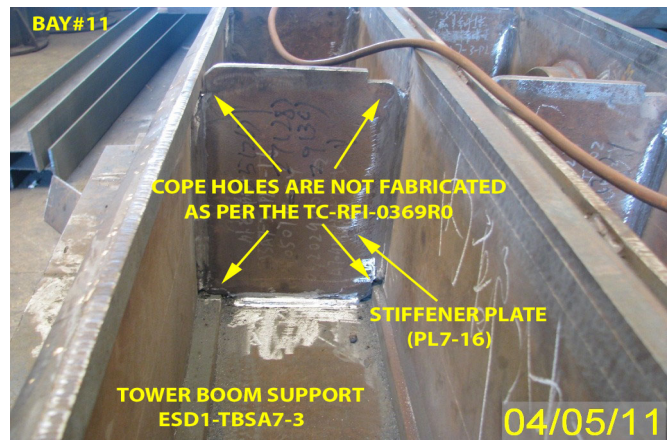
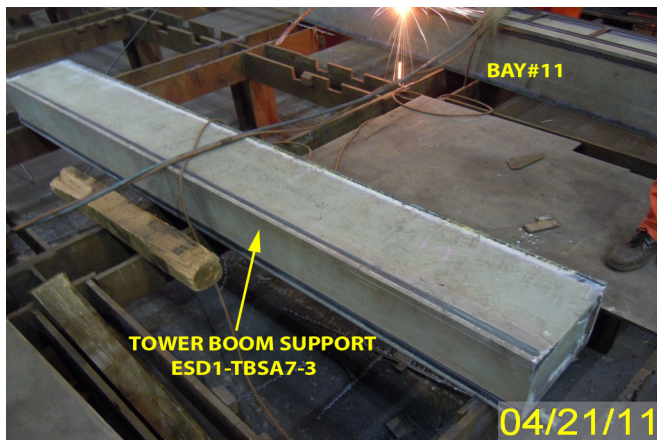
-Contract change order- CCO 77 "This change order provides enhanced weld reporting, a Quality Assurance data base along with a fabricated assembly tagging procedure (green tagging procedure). The implementation of the database system will provide traceability, organization, and reporting functions, which will be utilized in conjunction and to support the physical tagging procedure. These enhancements will allow the Department's QA personnel to verify the QC process in a timely fashion, mitigating possible schedule delays."

Section 3.2. Prior to submitting components for formal acceptance the contractor shall implement in-process verification that shall include the following:

3.2.3 All contract required visual inspections have been performed and is documented on the component as being acceptable

For further information, please see the attached pictures below.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversations.

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho - 15002048250, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer